

Date: Wednesday, 11/23/2005 8:40:31 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CHAFING SHIELD		
Job Number	: 24860					
Estimate Number	: 10840					
P.O. Number	: N/A			Part Number	: D31891	
This Issue	: 11/23/2005	S.O. No.	: N/A	Drawing Number	: D3189 REV A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A	Type	: PURCHASED PARTS	Drawing Revision	: A	
Previous Run	: 24860			Material	: N/A	
Written By	: See comment below			Due Date	: 12/15/2005	Qty: 10 Um: Each
Checked & Approved By	: See comment below					
Comment	: Est. B 05.08.22 No longer made in-house KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S25GA	304/316 .020" Sheet	
		Comment: Qty.: 0.3360 sf(s)/Unit Total : 3.3600 sf(s) 304/316 SS .020" Sheet (M304S25GA) Batch: M2070	
2.0	SHEAR	SHEAR	
		Comment: SHEAR Cut to size as per Dwg D3189	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		Deburr & Grind Rads as per Dwg D3189	
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
5.0	OUTSIDE SERVICE	OUTSIDE SERVICES	
		Comment: Sub-Contracting OUTSIDE SERVICES Issue P/O: 00000291 05/12/15 Roll D3189-1 as per Dwg D2646 Possible Supplier: Metec/Mast.	

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Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

C 205112115

(10)

7.0 QC6

DIMENSIONAL CHECK



10

Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3189

J 20512-16

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 90

10/05/12/16

(10)

9.0 DC

DOCUMENT CONTROL



10

Comment: DOCUMENT CONTROL

Inspection Level 21

545 05/12/20

10

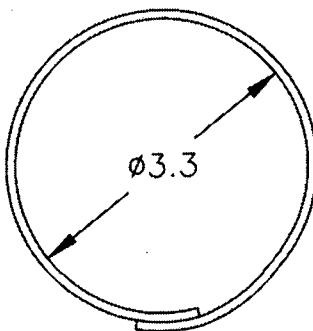
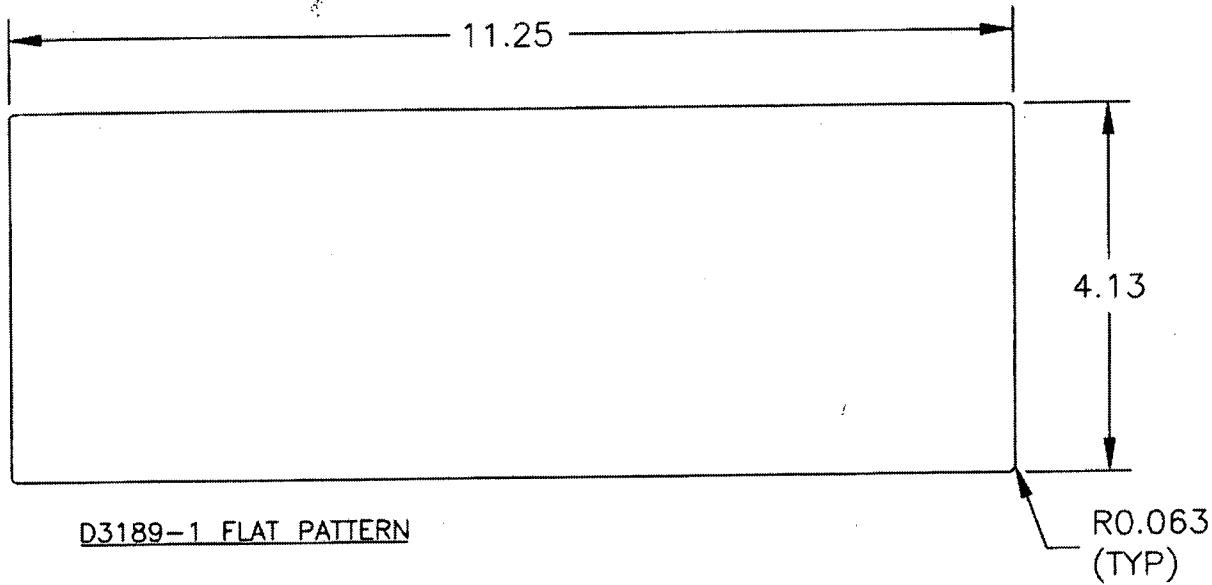
(10) ash20

Job Completion



DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3189	REV. A SHEET 1 OF 1
DATE 03.05.08		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.08	NEW ISSUE	

RELEASED
03.05.08 *[Signature]*

D3189-1 ROLLING DETAIL
NOT TO SCALE

D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 05/21/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No : 0024860
Project Name : D3189-1
Project For : WK550
Work Order Type : Main
Main WO Number :
House Part Number : D3189-1
Description : Chafing Shield
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 11-17-05
Est Finish Date : 12-15-05
Act Finish Date :
Drawings Reqd : No
Ok for Approval :
Approval Rec'd :
Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Delivery Slip: 15256
 Date: 15-Dec-2005
 Page No.: 1

Sold To: Dart Aerospace Ltd.
 Att. Linda Lacelle
 1270 Aberdeen Street
 Hawkesbury, Ontario
 K6A 1K7

Ship To: Dart Aerospace Ltd.
 Att. Linda Lacelle
 1270 Aberdeen Street
 Hawkesbury, Ontario
 K6A 1K7

P.O. Number	104508	Shipped by our truck			
Description		Quantity ordered	shipped	B/O	Unit
D3189-1 Chafing Shield	205112115		10		Each
P/O # 291 <i>J 05.12.06</i>					
Received by:	Thank you for your order.				